

# Work Order ID 47875 -1

June 26, 2009 7:29:56 AM



Page 1

Item ID: D3684-045  
Revision ID: C  
Item Name: LEG ASSEMBLY

Accept



Setup Start



Stop



Start Date: 15/07/2009 Start Qty: 3.00

Required Date: 03/08/2009 Req'd Qty: 3.00



Cust Item ID:

Customer:



Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3684	Rev C

100	Pick Kit	0.00
-----	----------	------



Packaging

Packaging

Memo

0.00

SB

09/08/07 (3)

110	Small Fab	0.00
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Small Fab

Small Fab

Memo

0.00

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684 112-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684 \*\*\*Ensure holes for AN3C Bolts are free of

SB 09/08/07

3

120	QC5- Inspect part completeness to step on W/O	0.00
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QC

Quality Control

Memo

0.00

SB 09/08/31

# Work Order ID 47875

June 26, 2009 7:29:56 AM



Page 2

Item ID: D3684-045  
Revision ID: C  
Item Name: LEG ASSEMBLY

Accept



Setup Start



Stop



Start Date: 15/07/2009 Start Qty: 3.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

MF 09-09-01

09/09/01 HJ

MF 09-09-02

# Picklist Print

June 26, 2009 7:29:55 AM

Work Order ID: 47875

Parent Item: D3684-045RevC

Parent Item Name: LEG ASSEMBLY









Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C12A 		Purchased	No			110	Each	0.0000	6.0000			
Bolts D3688-5RevB 		Manufactured	No			110	Each	0.0000	3.0000			
STUD D3689-1RevB 		Manufactured	No			110	Each	0.0000	3.0000			
* SLEEVE D3691-1RevU/R 		Manufactured	No			110	Each	0.0000	3.0000			
* STUD D3692-1RevB 		Manufactured	No			110	Each	0.0000	12.0000			
* SPACER D3693-1RevU/R 		Manufactured	No			110	Each	0.0000	3.0000			
Rod End Bearing MS21043-3 		Purchased	No			110	Each	0.0000	6.0000			
Nut NAS509L12C 		Purchased	No			110	Each	0.0000	3.0000			
Nuts												

M110584 SB -2

B46054 SB -1

B46051 SB -1  
B50722 SB (1)

B50736 SB -4

B50734 SB -1

M111819 SB -4

M110844 SB -1

M112453 SB 08/05/07

\* NAS509L-12C  
Mon 08/27



# Process Sheet

Order Number : CU-DAR001 Dart Helicopters Services  
Drawing Name : INBOARD LEG ASS'Y  
Estimate Number : 47875  
Part Number : D3684045  
P.O. Number : 13174  
Drawing Number : D3684 REV C  
This Issue : 11/05/2009 S.O. No. :  
Project Number : N/A  
Prsht Rev. : NC  
Drawing Revision : C  
First Issue : 1/1 Type : MACHINED PARTS  
Material :  
Previous Run : 45523 Due Date : 05/06/2009 Qty: 3 Um: Each  
Written By :  
Checked & Approved By : JLD 09-05-11  
Comment : Est Rev:A new issue 08-02-12 DD verified by:JLM  
Est Rev:B As per Rev B 09-01-07 JLM Verified By:EC  
Est Rev:C Added sealant note as per Rev C 09-01-20 JLM  
Verified By:DD

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

2.0

D36885

STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

STUD

batch B 46254

SB

3.0

D36891

SLEEVE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

SLEEVE

batch B 46251

SB

4.0

D36911

STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

STUD

batch 50722

SB

5.0

D36921

SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

SPACER

batch 153D738

SB 09/08/27

Job Number: 47875

Part Number: D3684045

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D36931	Rod End Bearing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Rod End Bearing

batch M50734

S

7.0	AN3C12A	Bolts
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolts

batch M110584

S

8.0	MS210433	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

batch M111519

S

9.0	NAS509L12C	Nuts
-----	------------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Nuts

batch M110314

S

10.0	NAS50912C	Nuts
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Nuts

batch M112453

S

11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684

2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684

\*\*\*Ensure holes for AN3C Bolts are free of sealant.

Torque Fastners as per Dwg D3684

S 09/09/27 (3)



# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INBOARD LEG ASSY

Job Number: 47875

Part Number: D3684045

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: \_\_\_\_\_

14.0

QC21

FINAL INSPECTION/W/O RELEASE

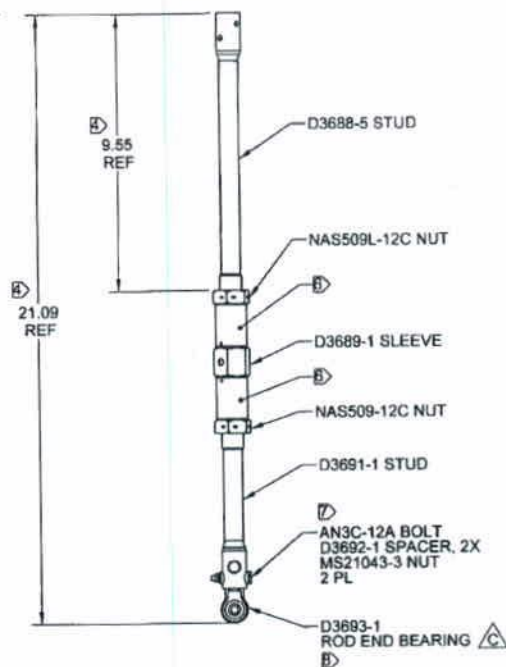


Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



ITEM	QTY .045	PART NUMBER	DESCRIPTION
1	X	D3684-045	INBOARD LEG ASSEMBLY
2	1	D3688-5	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



**D3684-045 INBOARD LEG ASSEMBLY**

**RELEASED**  
07/01/2015

**NOTES:**

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-045 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSION SHOWN IS WHEN D3688-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.1 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3684	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	'NTS
DATE	08.12.15	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED. IT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR REPRODUCED IN ANY FORM, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

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